Work Order Wednesday, April 1				*100		Page 1							
Revision ID:	4062-3 ower Tank Su	ıpport		Accept	*N900)040	100)*	Setup	Start Stop	ריעו		
Start Date: 4/ Required Date: 4/2 Reference:	717/2013	Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*		Cust Item Customer:						1 4	() /	
		n: MUF.	Date: 13-4-17 Date:	Tooling: SPC (Y/N):		Pate:			Run	Start Stop	1/1	R1* R2*	
Sequence ID/ Work Center ID		Operation Description		Set Up/ Run Hours	Tool ID	Tool#		Accept Qty	Rej Qty		Reject Number	Insp. Stamp	
Draw Nbr	Revi	sion Nbr											
D4062	C												
*100 *100* Waterjet FLOW CNC Waterjet		Memo CUT AS PI dwg rev: prog rev:	ER FILE D4062-3	0.00				_1_	-		(OAS (05)	13.04.2
*102 *102* QC Quality Control		QC2- Inspect parts off r Memo	nachine FAI/FAIB	0.00		·					(\$\frac{1}{9}\$	13 o4.ô
130 *130* QC		QC8- Inspect parts - sec	ond check	0.00 27	1 2		٠.	1	·				

Quality Control

										DQA:	Date	:
NCR:	Yes / No				WORK ORDER NON-O	CON	IFORM	MANCE / UP		QA Closed:	 Date	,.
	 				DISPOSITION	I			AGAINST DE			·
Work Orde	er:					,				1		- \square
Part N	No				Rework Scrap Use-as-is		1	Skid-tube Machining noforming	Crosstube Small Fab Finishing		Water Jet d. Eng. Coor re/Packaging	Engineering Quality Other
NCR N	No				Work Order Update]		Large Fab	Composite	,	Supplier	
Root	,			Descri	ption of work order update	lı	nitial	Ac	tion	Sign &		
Cause	Date	Step	Qty	(or Non-conformance	Chi	ef Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data				•								
Equip/Tooling		}										
Operator												
Material												
Setup												
Other												ļ
Process			'									
Supplier												
Training												
Unapproved										<u></u>	<u></u>	
						AUL.	T CATE	GORY	****			
Landii	ng Gear			_	General				 	1	<u></u>	٦. (- ,
	Bending				Bend	-	Grain		<u> </u>	Ovalized	, ₁ ,	Pressure/Forced
	Centre No	ot Concei	ntric to C	^{0/S}	BOM/Route	\vdash	Hardwa		<u> </u>	Over/Under	⊢	Temperature/Cure
	Cracks			<u> </u>	Broken/Damaged	-	•	on incomplete	,,	Part Incorre	<u> </u>	Weld
	Crushed/	Crimped.			Burrs			ions incomplete/	Unclear	Part Lost/M	_	Wrong Stock Pulled
	Cuffs				Contamination	-	Mainte		<u> </u>	Part Moved		
			Countersink	\vdash	Mislabeled			Positioned V		Other		
	Inspectio	•	Tube		Cut Too Short	\vdash	Misread	I	<u>L</u>	Power Loss/	onige [Jourer
	Ripples ir			-	Drill Holes	-	Offset	Salth and a				
	Torque W	/aves in E	xtrusion		Drawing	1 1	Out of (Calibration				

Out of Sequence

Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G

Work Orde Wednesday, April				*100078*								Page 2
Revision ID: Item Name:	D4062-3 Lower Tank 9 4/17/2013 4/26/2013	Support Start Qty: 5.00 Req'd Qty: 5.00	*5* *5*	Accept	*N900 Cust Item I Customer:		100)*	Setup	Start Stop	I V	S1* S2*
Reference: Approvals:	Process Pl	an:	Date:	Tooling:	n.	nte:	-		Run	Start	*NI	R1*
	QC:		Date:	SPC (Y/N):		ite:				Stop	.1.6	R2*
Sequence ID/ Work Center ID 140 *140 *neckaging Packaging)	Operation Description Identify as per dwg & Sto	ock Location: WROO	Set Up/ Run Hours 0.00	Tool ID	Tool#	Plan Code	Accep Qty	t Rej Qty		Reject Number	Insp. Stamp
150		QC21- Final Inspection -	Work Order Release	0.00						. .	6.10	1)

0.00

Memo

150

Quality Control

A12-0124

											DQA:	Date:	
NCR:	Yes	/ No				WORK ORDER N	ION-CO	NFORM	MANCE / UPD	ATE			
											QA Closed:	Date:	
Work Ord	or.					DISPOSITION	1			AGAINST DE	PARTMENT	/PROCESS	
Part I	No.					Use-a	rap s-is	Therm	Skid-tube Machining noforming	Crosstube Small Fab Finishing	-	Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
NCR I	NO.					Work Order Upd	ate		Large Fab	Composite	J	3upplier	
Root					Descri	otion of work order up	date	Initial	Acti	on	Sign &		
Cause		Date	Step	Qty	C	or Non-conformance	C	hief Eng	Descri	ption	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling												,	
Operator													
Material													
Setup			İ										
Other											·		
Process													
Supplier													
Training			ļ	1 1			· .						
Unapproved											<u> </u>		<u></u>
							FAU	ILT CATE	GORY				
Landi	ing G	ear				General				_	7		7
		Bending				Bend	<u> </u> _	Grain			Ovalized	<u> </u>	Pressure/Forced
	Centre Not Concentric to O/S BOM/Route					BOM/Route		Hardwa	re		Over/Under	tolerance	Temperature/Cure
						Broken/Damaged		Inspecti	on Incomplete	_	Part Incorre	ct	Weld
	Crushed/Crimped.					Burrs		Instruct	ions Incomplete/U	nclear	Part Lost/M	issing	Wrong Stock Pulled
	Cuffs					Contamination		Mainte	nance	_	Part Moved		
	Heat Treat				Countersink		Mislabe	led		Positioned \	Wrong	-	
		Inspectio	n Strip in	Tube		Cut Too Short		Misread	i		Power Loss,	'Surge	Other
	Ripples in Bend					Drill Holes		Offset					

Out of Calibration

Outside Dimensions

Out of Sequence

Turning Sequence

Wave/Twist in Tube

Torque Waves in Extrusion

Drawing

Finish

Folio

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Picklist Print

Wednesday, April 17, 2013 4:11:35 PM

Work Order ID:

100078

Parent Item:

D4062-3

Parent Item Name:

Lower Tank Support

Start Date: 4/17/2013

Required Date: 4/26/2013

Start Qty: 5.00

Required Qty: 5.00

Comments:

IPP REV:A NEW ISSUE 11-11-28 JLM VERIFIED BY:DD

IPP REV:B AS PER REV C 12-

	03-08 JLM VERI	FIED BY:DD											
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB250		Purchased	No				sf	49.0000		14.210526		1	
UHMWB .250 BLACK												۱۱ ۱۵۰	OH. 22

Page 1

											DQA:	Date	: :
NCR:	Yes .	/ No				WORK ORDER NON-	CONI	FORN	MANCE / UP	DATE	QA Closed:	 Date	•
			···			DISPOSITION				AGAINST DE			·
Work Orde	_					Rework			Skid-tube	Crosstube Small Fab) Dro	Water Jet d. Eng. Coor.	Engineering Quality
Part N NCR N				<u> </u>		Scrap Use-as-is Work Order Update	-	Therm	Machining noforming Large Fab	Finishing Composite	-i	re/Packaging Supplier	Other
						<u> </u>	_				·		
Root					Descri	ption of work order update	1	itial		tion	Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Chie	f Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data													
Equip/Tooling												`	
Operator	Ш		·										
Material													
Setup	Ш												
Other							-						
Process	Н											·	
Supplier	\vdash												
Training	Н												
Unapproved	LL.		L	<u>. </u>			ALLET	CATE	SORV				
Landir	ng Ge	ar				General	AULI	CATE	3011		-		
		ending				Bend	Па	arain			Ovalized	Γ	Pressure/Forced
		entre No	ot Concei	ntric to	o/s	BOM/Route	\vdash	lardwa	re		Over/Under	tolerance	Temperature/Cure
	_	racks				Broken/Damaged	$\boldsymbol{\vdash}$		on Incomplete		Part Incorre	<u> </u>	Weld
	_	rushed/0	Crimped.			Burrs			ions Incomplete/	'Unclear	Part Lost/M	issing	Wrong Stock Pulled
	_	uffs	•			Contamination	-		nance		Part Moved	_	
İ	П	leat Trea	t			Countersink	\prod_{i}	∕islabe	led		Positioned \	Vrong	<u>_</u> ;
Ì		nspection	n Strip in	Tube		Cut Too Short	\square	/lisreac	1	· .	Power Loss/	Surge	Other
ļ	R	ipples in	Bend			Drill Holes		Offset		. —			
	Torque Waves in Extrusion				n [Drawing		ot of C	Out of Calibration				

Out of Sequence

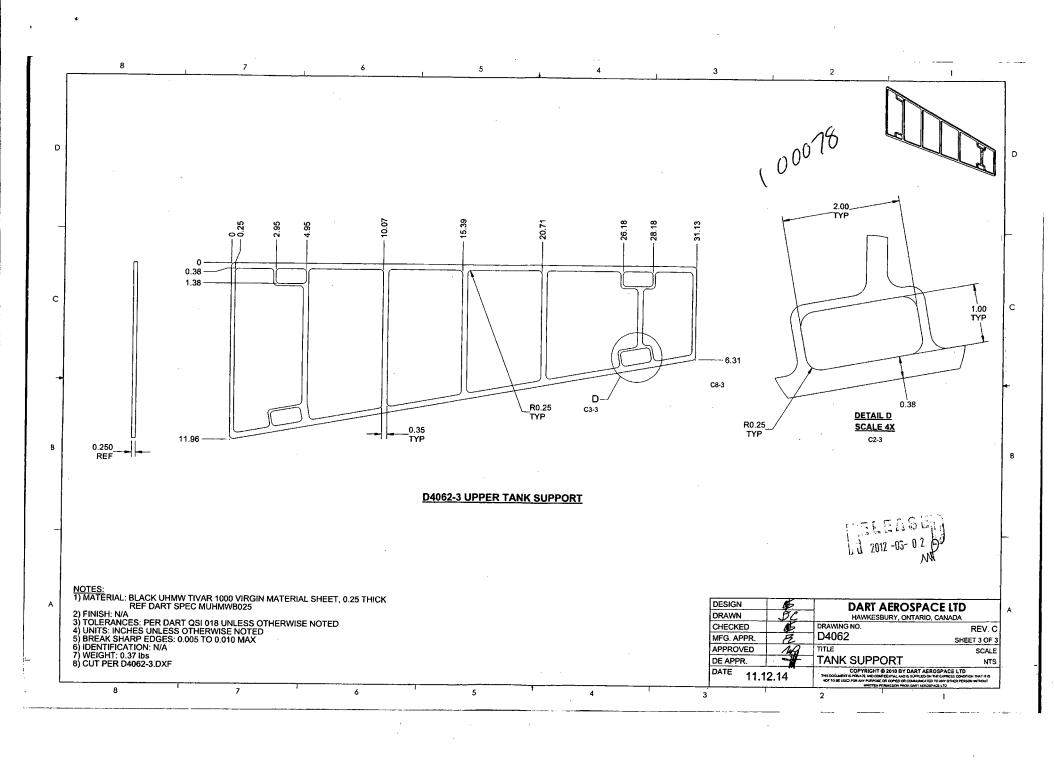
Outside Dimensions

Turning Sequence

Wave/Twist in Tube

Finish Folio

H:/FORMS/Quality Assurance\approved QA/NCRWO Rev G



									DQA:	Date:	
NCR: Yes	s / No				WORK ORDER NON-C	CONFORI	MANCE / UPI		QA Closed:	Date:	
Work Order:					DISPOSITION			AGAINST DE	PARTMENT	/PROCESS	
Part No.	•				Rework Scrap Use-as-is Work Order Update	4 1	Skid-tube Machining moforming Large Fab	Crosstube Small Fab Finishing Composite		Water Jet d. Eng. Coor. re/Packaging Supplier	Engineering Quality Other
Root				Descri	ption of work order update	Initial	Act	tion	Sign &		
Cause	Date	Step	Qty		or Non-conformance	Chief Eng	Desc	ription	Date	Verification	QC Inspector
Doc/Data											
quip/Tooling].			:							
Operator	_]									;	
Material	_	1									
Setup	_						1		:		
Other											
rocess											
Jupaliar	1	1	1			1	1				1

FAULT CATEGORY Landing Gear General Pressure/Forced Bend Grain Ovalized Bending BOM/Route Over/Under tolerance Temperature/Cure Centre Not Concentric to O/S Hardware Weld Broken/Damaged Inspection Incomplete Part Incorrect Cracks Wrong Stock Pulled Part Lost/Missing Crushed/Crimped. Instructions Incomplete/Unclear Burrs Maintenance Part Moved Cuffs Contamination Positioned Wrong Mislabeled Heat Treat Countersink Other Power Loss/Surge Misread Inspection Strip in Tube Cut Too Short Drill Holes Offset Ripples in Bend Torque Waves in Extrusion Drawing Out of Calibration Turning Sequence Finish Out of Sequence Outside Dimensions Folio

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Wave/Twist in Tube

Training Unapproved

DART AEROSPACE LTD	Work Order:	100078
Description: Lower Tank Support	Part Number:	D4062-3
Inspection Dwg: D4062 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
1.00	+/-0.030	1.005	/		1/	JKM-01
2.00	+/-0.030	2.004			V	010-1 0)
0.25	+/-0.030	0,233	V		3/	
2.95	+/-0.030	2.934	V		V	
4.95	+/-0.030	4.947	V		V	
10.07	+/-0.030	10.07	/		\mathcal{T}°	JKM-06
15.39	+/-0.030	15.39	V		7	UN/9-00
20.71	+/-0.030	20.71	V		7	
26.18	+/-0.030	26.18	/		7	
28.18	+/-0.030	28.18	1/	· · · · · · · · · · · · · · · · · · ·	7	
31.13	+/-0.030	31.13	V		7	
0.38	+/-0.030	0.376	/		1/	
1.38	+/-0.030	1.38	1	· · · · · · · · · · · · · · · · · · ·	1/	
11.96	+/-0.030	11.96	/		7	
0.35	+/-0.030	0.354	/		V	
6.31	+/-0.030	6.31	1/		V	
0.250	+/-0.010	0.245	V		V	
			- John 1			

			_	
Measured by:	Audited by:	5-60	Preliminary Approval:	
Date: 13.04.22	Date:	13423	Date:	

Rev	Date	Change	·	Revised by	\overline{a}	Approved
Α	12.05.15	New Issue		KJ ds	4-7-	777
			1	7)	4	- Joy

NCR: Y	⁄es	/ No				WORK ORDER NON-CONFORMANCE / UPDATE QA Closed: Date:								
Work Orde	or:					DISPOSITION				AGAINST	DE	PARTMENT	/PROCESS	
Part N	- No					Rework Scrap Use-as-is Work Order Update	Machining Small Fab Thermoforming Finishing Large Fab Composite					Prod Rec/Stor	Engineering Quality Other	
Root	T					ption of work order update	1	Initial		ction		Sign &		
Cause		Date	Step	Qty	(or Non-conformance	Ch	ief Eng	Des	cription		Date	Verification	QC Inspector
Doc/Data Equip/Tooling Operator Material Setup Other Process Supplier Training Unapproved													,	
						F	AUI	T CATE	GORY			·		
Landi	ng G	ear				General		_			_	, ·	_	_
	-	Bending Centre No	ot Conce	ntric to	0/5	Bend BOM/Route	-	Grain Hardwa	ıre		-	Ovalized Over/Under	tolerance	Pressure/Forced Temperature/Cure

Hardware

Maintenance

Out of Calibration

Out of Sequence

Outside Dimensions

Mislabeled

Misread

Offset

Inspection Incomplete

Instructions Incomplete/Unclear

BOM/Route

Contamination

Countersink

Cut Too Short

Drill Holes

Drawing

Finish Folio

Burrs

Broken/Damaged

DOA:

Part incorrect

Part Moved

Part Lost/Missing

Positioned Wrong

Power Loss/Surge

Date:

Weld

Other

Wrong Stock Pulled

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Ripples in Bend

Turning Sequence

Wave/Twist in Tube

Cracks

Cuffs

Heat Treat

Crushed/Crimped.

Inspection Strip in Tube

Torque Waves in Extrusion

Centre Not Concentric to O/S